

09-19-00

PTO/SB/05 (2/88)  
Patent and Trademark Office: U.S. DEPARTMENT OF COMMERCE  
Approved for use through 09/30/2000. OMB 0851-0032  
Under the Paperwork Reduction Act of 1995, no persons are required to respond to a collection of information unless it displays a valid OMB control number.

Please type a plus sign (+) inside this box → ☒

Under the Paperwork Reduction Act of 1995, no persons are required to respond to a collection of information unless it displays a valid OMB control number.

# UTILITY PATENT APPLICATION TRANSMITTAL

(Only for new nonprovisional applications under 37 C.F.R. § 1.53(b))

Attorney Docket No. 3491-42  
First Inventor or Application Identifier Goran Nilsson et al.  
Title Use of a Transfer Belt for a Soft Tissue...  
Express Mail Label No. EK052280938US

**APPLICATION ELEMENTS**  
See MPEP chapter 600 concerning utility patent application contents.

**ADDRESS TO:** Assistant Commissioner for Patents  
Box Patent Application  
Washington, DC 20231

- ☒ \* Fee Transmittal Form (e.g., PTO/SB/17)  
(Submit an original and a duplicate for fee processing)
- ☒ Specification [Total Pages 12] 1  
(preferred arrangement set forth below)
  - Descriptive title of the invention
  - Cross References to Related Applications
  - Statement Regarding Fed sponsored R & D
  - Reference to Microfiche Appendix
  - Background of the invention
  - Brief Summary of the invention
  - Brief Description of the Drawings (if filed)
  - Detailed Description
  - Claim(s)
  - Abstract of the Disclosure
- ☒ Drawing(s) (35 U.S.C. 113) [Total Sheets 4] 1
- Oath or Declaration [Total Pages ]
  - ☐ Newly executed (original or copy)
  - ☐ Copy from a prior application (37 C.F.R. § 1.63(d))  
(for continuation/divisional with Box 17 completed)  
(Note Box 5 below)
    - ☐ **DELETION OF INVENTOR(S)**  
Signed statement attached deleting inventor(s) named in the prior application, see 37 C.F.R. §§ 1.63(d)(2) and 1.33(b).
- ☐ Incorporation By Reference (useable if Box 4b is checked)  
The entire disclosure of the prior application, from which a copy of the oath or declaration is supplied under Box 4b, is considered to be part of the disclosure of the accompanying application and is hereby incorporated by reference therein.

- ☐ Microfiche Computer Program (Appendix)
- Nucleotide and/or Amino Acid Sequence Submission (if applicable, all necessary)
  - ☐ Computer Readable Copy
  - ☐ Paper Copy (identical to computer copy)
  - ☐ Statement verifying identity of above copies

## ACCOMPANYING APPLICATION PARTS

- ☐ Assignment Papers (cover sheet & document(s))
- ☐ 37 C.F.R. § 3.73(b) Statement (when there is an assignee) ☐ Power of Attorney
- ☐ English Translation Document (if applicable)
- ☒ Information Disclosure Statement (IDS)/PTO-1449 ☒ Copies of IDS Citations
- ☒ Preliminary Amendment
- ☒ Return Receipt Postcard (MPEP 503)  
(Should be specifically itemized)
  - \* Small Entity Statement(s) ☐ Statement filed in prior application, (PTO/SB/09-12) Status still proper and desired
- ☐ Certified Copy of Priority Document(s) (if foreign priority is claimed)
- ☐ Other: .....

\* NOTE FOR ITEMS 1 & 14: IN ORDER TO BE ENTITLED TO PAY SMALL ENTITY FEES, A SMALL ENTITY STATEMENT IS REQUIRED (37 C.F.R. § 1.27), EXCEPT IF ONE FILED IN A PRIOR APPLICATION IS RELIED UPON (37 C.F.R. § 1.28).

17. If a CONTINUING APPLICATION, check appropriate box, and supply the requisite information below and in a preliminary amendment:

☒ Continuation ☐ Divisional ☐ Continuation-in-part (CIP) of prior application No: PCT / SE99/00434  
Prior application Information: Examiner \_\_\_\_\_ Group / Art Unit: \_\_\_\_\_

## 18. CORRESPONDENCE ADDRESS

☐ Customer Number or Bar Code Label (Insert Customer No. or Attach bar code label here) or ☒ Correspondence address below

Name	Joseph C. Sullivan				
Address	Pitney, Hardin, Kipp & Szuch LLP 711 Third Avenue, 20th Floor				
City	New York	State	New York	Zip Code	10017
Country	U.S.A.	Telephone	212-687-6000	Fax	212-682-3485

Name (Print/Type)	John F. Gulbin	Registration No. (Attorney/Agent)	33,180
Signature	<i>John F. Gulbin</i>	Date	Sept. 18. 2000

Burden Hour Statement: This form is estimated to take 0.2 hours to complete. Time will vary depending upon the needs of the individual case. Any comments on the amount of time you are required to complete this form should be sent to the Chief Information Officer, Patent and Trademark Office, Washington, DC 20231. DO NOT SEND FEES OR COMPLETED FORMS TO THIS ADDRESS. SEND TO: Assistant Commissioner for Patents, Box Patent Application, Washington, DC 20231.

3491-42

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant: Goran Nilsson et al.

Serial No.:

Group:

Filed: concurrently herewith Examiner:

For: Use of a Transfer Belt for a Soft Tissue Paper  
Machine

711 Third Avenue  
New York, New York 10017  
212-687-6000

PRELIMINARY AMENDMENT

Box Patent Application  
Commissioner for Patents  
Washington, D.C. 20231

S I R:

Prior to conducting a first examination of the above  
application, kindly amend said application as follows:

629388A01091800

Express Mail Label No. EK052280938US

In the Specification:

On page 1, in the space between the title, "Use of a Transfer Belt for a Soft Tissue Paper Machine", and line 1, "The present invention relates ...", please insert:

-- Cross Reference to Related Application

This is a continuation of International Application No. PCT/SE99/00434, which was filed on March 19, 1999 and in which the United States was designated.--;

In the Claims:

In claim 3, line 1, please delete "or 2";

In claim 4, line 1, delete "any one of claims 1-3" and substitute therefor --claim 1--;

In claim 5, line 1, delete "any one of claims 1-4" and substitute therefor --claim 1--;

In claim 6, line 1, delete "any one of claims 1-5" and substitute therefor --claim 1--;

In claim 7, line 1, delete "any one of claims 1-5" and substitute therefor --claim 1--; and

In claim 8, line 1, delete "any one of claims 1-7" and substitute therefor --claim 1--.

REMARKS

Entry of the preceding amendment, which is being submitted to insert a cross reference to an earlier application and to eliminate improper multiple dependent claims, is respectfully requested, as is an early first examination of the claims as amended.

Respectfully submitted,



John F. Gulbin  
Registration No. 33,180

Pitney, Hardin, Kipp & Szuch LLP  
711 Third Avenue, 20<sup>th</sup> Floor  
New York, New York 10017  
212-687-6000

USE OF A TRANSFER BELT FOR A SOFT TISSUE PAPER MACHINE

The present invention relates to the use of a transfer belt for a soft tissue paper machine.

DE-195 48 747 discloses a paper machine for making creped tissue, which has a press comprising a shoe press roll, a counter roll and a suction roll, the counter roll forming a first press nip with the suction roll and a second extended press nip with the shoe press roll. A felt runs through the two press nips together with the paper web and then brings along the paper web to a Yankee cylinder, to which the paper web is transferred when the felt and the paper web pass round a transfer roll, which forms a non-compressing nip with the Yankee cylinder. Suction zones for dewatering the felt are available before and after the first press nip, the suction zone before the press nip being located inside the suction roll while the suction zone after the press nip is located in a side loop, in which the felt runs alone to meet again the paper web at the entry of the second press nip. Such a paper machine is inconvenient since the paper web is rewet by the wet felt before it reaches the Yankee cylinder.

US-A-5,393,384 discloses a paper machine for producing a tissue web, which in the embodiment according to Fig. 6 comprises a non-compressible, water-impermeable belt, the underside of which conducts a paper web through a shoe press nip and from there to a Yankee cylinder, via a transfer roll which forms a nip with the Yankee cylinder. This impermeable belt has a smooth web-carrying surface which makes an adhesive water film form thereon as the belt passes through the press nip together with a press felt which has a non-smooth surface in contact with the paper web. As is known, a Yankee cylinder has a smooth surface. Since both the Yankee cylinder and the impermeable belt have smooth surfaces which the paper

EK0522809380S

	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
0	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100

	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
0	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100

[illegible][illegible][illegible]

to a dryer fabric which brings the transferred web to a dryer cylinder.

The transfer belt disclosed in US-5,298,124 for the press section of a paper machine has a web-contacting surface which is essentially impermeable to water and air and which has a pressure-responsive microscale topography. Under the action of the pressure in a press nip of the press section, the transfer belt is compressed such that the microscale roughness of said surface decreases, making the surface much smoother and allowing a thin, continuous film of water to be built up between the paper web and said surface. The thin, continuous film of water provides much stronger adhesive forces between the paper web and the transfer belt than between the paper web and the press fabric, so that the paper web may reliably follow the transfer belt as the paper web leaves the press nip. In this connection, the transfer belt expands in the direction of thickness and approaches its non-compressed state such that the film of liquid on said web-contacting surface breaks up.

According to the invention, it has surprisingly been found that a belt of the type according to US-A-5,298,124 is well suited also for the transfer of a soft tissue web in a closed draw from a shoe press nip in the press section to a Yankee cylinder in the dryer section of a soft tissue paper machine. As is known, a shoe press nip results in a great degree of dewatering.

The essentially impermeable and elastically compressible transfer belt according to the invention thus consists of an endless carrier, alternatively comprising a joinable seam, with a polymer coating on its web-contacting surface having a hardness of 50-97 Shore A, the polymer coating having a non-compressed degree of roughness of  $R_z = 2-80 \mu\text{m}$ , measured according to ISO 4287, Part I, and is compressible to a lower degree of roughness of  $R_z = 0-20 \mu\text{m}$  when a linear load of 20-200 kN/m is applied to the essentially impermeable belt and is

capable of being reset to its non-compressed degree of roughness when the pressure acting on the essentially impermeable belt ceases. The  $R_z$  value is the ten point height that in said ISO standard is defined as the average distance between the five highest crests and the five deepest troughs of the reference length measured from a line which is parallel to the centre line and does not intersect the surface profile. Preferably the essentially impermeable transfer belt has an air permeability of less than  $6 \text{ m}^3/\text{m}^2/\text{min}$  measured according to "Standard Test Method for Air Permeability of Textile Fabrics, ASTM D 737-75, American Society of Testing and Materials".

It is surprising that such a transfer belt, which according to US-A-5,298,124 is intended for pressing in a press section and usable for transfer of a paper web from the press section to a dryer fabric, is usable in a very advantageous manner to transfer a soft tissue web from a shoe press nip directly to a Yankee cylinder. In a Yankee cylinder, the conditions are, in fact and as is known, quite different from those in a press nip. In a Yankee cylinder, there is no pressing of the soft tissue web for direct dewatering, but it is instead a matter of supporting the soft tissue web against the outer surface of the Yankee cylinder, such that the fibres of the soft tissue web adhere to the surface of the Yankee cylinder in order to get stuck by burning, thereby obtaining good thermal transmission to the paper web. Precisely this effect is achieved by the inventive transfer belt, which cannot be achieved by a press felt according to DE 195 48 747 owing to the above-mentioned rewetting of the paper web after the last press nip in the press section, which prevents good adhesion, and cannot be achieved or is achieved to a substantially smaller extent by a transfer belt according to US-5,393,384, for the reason described above. The compressibility of the inventive transfer belt results in a lower specific pressure in the adhesion point, which in turn entails increased runnability, i.e. a higher pro-



duction rate. Moreover, this property causes an increased evaporation of water from the soft tissue web, i.e. quicker drying of the soft tissue web on the Yankee cylinder, which also contributes to a higher efficiency of the process. The increased efficiency can be used either as a higher machine speed or as a reduced consumption of energy while retaining the production volume.

The invention will now be described in more detail with reference to the accompanying drawings, in which

Fig. 1 shows a paper machine with a transfer belt according to the invention,

Fig. 2 shows another paper machine with a transfer belt according to the invention,

Fig. 3 shows one more paper machine with a transfer belt according to the invention, and

Fig. 4 shows a further paper machine with a transfer belt according to the invention.

Figs 1-4 are schematic views of parts of paper machines for making a fibrous web 1 of soft tissue paper, such as sanitary paper products. Each of the paper machines comprises a wet section 2, a press section 3 and a dryer section 4.

The wet section 2 comprises a head box 7, a forming roll 8, an endless, carrying inner clothing 9 and an endless, covering outer clothing 10, which consists of a forming fabric. The inner and outer clothings 9, 10 each run in a loop round a plurality of guide rolls 11, 12.

The dryer section 4 comprises a Yankee type dryer cylinder 5 which is covered with a hood 30. At the exit side of the dryer section there is a crepe doctor 21 which is adapted to crepe off the fibrous web 1 from the Yankee cylinder 5. Moreover there is an application means 31 for applying a suitable adhesive to the circumferential surface of the Yankee cylinder 5 just before the transfer nip.

The press section 3 comprises a shoe press having a shoe press roll 14 and a counter roll 19, said rolls 14,

19 forming an extended press nip with each other. Moreover the press section comprises an endless press fabric 15 which runs in a loop round the guide rolls 6, and an endless, essentially impermeable transfer belt 16. The  
5 essentially impermeable belt 16 runs in a loop round the counter roll 19, a transfer roll 17 and a plurality of guide rolls 18.

The transfer roll 17 forms with the Yankee cylinder 5 a transfer nip with a low linear load, through which  
10 transfer nip thus runs the essentially impermeable belt 16.

In the embodiments shown in Figs 1 and 2, the press section 3 also comprises a press, the rolls of which consist of a suction press roll 13 and said counter roll 19  
15 to form a press nip, through which the essentially impermeable belt 16 and the press fabric 16 run together with the fibrous web 1. After this initial press nip, the press fabric 15 is conducted away from the fibrous web 1 and the essentially permeable belt 16 in a side loop  
20 round the suction press roll 13 and two guide rolls 32. The press fabric 15 then again unites with the fibrous web 1 and the essentially impermeable belt 16 just before the extended press nip. If desired, suction means can be arranged in this side loop of the press fabric 15 in  
25 order to increase the water-absorbing capacity of the press fabric at the entry of the extended press nip.

In the embodiments shown in Figs 1 and 3, the inner clothing 9 of the wet section 2 is a fabric which is conducted to the press section 3 to be used also as a press  
30 fabric 15, and which thus in a loop runs back to the forming roll 8.

In the embodiment shown in Fig. 2, the inner clothing 9 of the wet section 2 is a fabric, the press fabric 15 running round a pick-up roll 20 which is arranged  
35 close to the loop of the fabric 9, such that the press fabric 15 and the fabric 9 run in contact with each other to transfer the fibrous web from the fabric 9 to the

press fabric 15. The pick-up roll 20 can be provided with a suction shoe (not shown). Alternatively, the pick-up roll with suction shoe can be replaced by a pick-up suction box.

5 Fig. 4 is a schematic view of parts of a paper machine according to a further embodiment of the invention, which is similar to the one shown in Fig. 1 except that the press fabric 15 in this case is not conducted in a side loop between the two press nips, but instead follows the counter roll 19, such that the fibrous web 1 is kept enclosed between the essentially impermeable belt 16 and the press fabric 15. This embodiment can be used when there is a small risk of rewetting of the fibrous web.

15 In the embodiments according to Figs 1-4, the counter roll 19 is a smooth roll and is arranged in the loop of the essentially impermeable belt 16. In an alternative embodiment (not shown) of the press section according to Fig. 3, the positions of the rolls 14, 19 are inversed, i.e. the shoe press roll 14 is arranged in the loop of the essentially impermeable belt 16 and the counter roll 19 in the loop of the press fabric 15. In such a configuration, the counter roll can be a suction roll, a grooved roll or a blind bore roll.

25 The polymer coating of the essentially impermeable transfer belt can, as stated in US-5,298,124, advantageously comprise a polymer composition, such as acryl polymer resin, polyurethane polymer resin and polyurethane/polycarbonate polymer resin composition. The polymer coating can also comprise a particulate filler, which has a hardness different from that of the polymer material and which can be, for instance, kaolin clay, polymer material or metal, preferably stainless steel.

35 It is possible to produce the inventive transfer belt in the way which is also disclosed in US-5,298,124.

By using the above components, the belt is provided with a surface layer which is elastically compressible.

After the actual surface treatment in the production process, a surface is obtained, which results in a controlled topography. The compressibility and topography of the surface layer are not affected to any considerable extent by the possible wear that may arise in operation.

The tight polymer surface is easy to keep clean and withstands cleaning by means of a doctor blade directly on the belt surface. For the belt not to age in the edge portions running against the Yankee cylinder outside the paper web, this must be taken into consideration when selecting materials, and the combinations should be selected which have optimal temperature stability. Otherwise, it is necessary to introduce edge cooling, for instance, by spraying water on the edge just before or after passing the Yankee cylinder.

The carrier of the transfer belt is endless and comprises all types of base elements that are in some way made endless. The expression comprises specifically also an openable seamed base element, which is made endless only when being installed in the paper machine by means of a suitable seam. The carrier may consist of, for instance, a multilayered woven fabric made of polymer monofilament yarn such as polyester, polyamide and the like. The base element can also consist of a fibrous web (nonwoven) kept together by a binder, joined wound threads, polymer foil/film, warp knit or the like.

The carrier must be dimensionally stable both in the machine direction and in the cross-direction, thereby contributing to the stability of the belt when subjected to mechanical stress in these directions.

If the carrier is desired to be completely enclosed in the polymer coating, it can either be applied to one side with complete bleeding-through to the rear side or be applied first to one side and then to the other.

There may be other configurations in which especially thin belts are desired, and it may then be suitable to apply the coating from one side only, in which

case the bleeding-through is limited. It is then essential that the non-coated surface of the base element is resistant to wear and easy to keep clean.

A paper machine with a transfer belt according to  
5 the invention and whose press nip/press nips is/are  
single-felted, produces a fibrous web which before the  
Yankee cylinder has a high dry solids content, i.e. up to  
55%, which is to be compared with the dry solids contents  
of up to 45% which are achieved in paper machines that  
10 are currently used in practice. This improvement can be  
used either to operate the paper machine with a higher  
production rate as mentioned above, or to reduce the con-  
sumption of energy in the dryer section, in which case  
there is also a possibility of reducing the diameter of  
15 the Yankee cylinder.

In the embodiments described and shown above, a  
guide roll can, if desired, be arranged in the loop  
of the essentially impermeable belt 16 just before the  
transfer roll 17.

20 In the embodiments described and shown above, use  
is made of a transfer means which consists of the trans-  
fer roll 17. According to an alternative embodiment (not  
shown), the transfer roll is replaced by the essentially  
impermeable belt itself, which is allowed to run round  
25 a predetermined part of the Yankee cylinder, for instance  
in a sector angle of 30-60°, with a view to forming an  
extended transfer nip with the dryer cylinder.

The inventive transfer belt can have a pattern on  
its side facing the paper web, thereby producing an  
30 embossed soft tissue web.

## CLAIMS

1. Use of an essentially impermeable transfer belt  
5 (16) for a soft tissue paper machine for conducting a  
soft tissue web (1) through a shoe press nip in the press  
section of the paper machine, and from the shoe press nip  
to a Yankee cylinder (5) in the dryer section of the  
10 paper machine in a closed draw, which Yankee cylinder  
forms, together with a transfer means (17), a transfer  
nip transferring the soft tissue web from the transfer  
belt to the Yankee cylinder, the transfer belt comprising  
a carrier and an elastically compressible polymer layer  
15 on its side facing the paper web, the polymer layer hav-  
ing a hardness between 50 and 97 Shore A and having a  
web-contacting surface which has a pressure-sensitive  
resettable degree of roughness, the web-contacting sur-  
face having a degree of roughness in a non-compressed  
20 state of  $R_z = 2-80 \mu\text{m}$ , measured according to ISO 4287,  
Part I, and a lower degree of roughness of  $R_z = 0-20 \mu\text{m}$   
when the polymer layer is compressed by a linear load of  
20-220 kN/m applied to the essentially impermeable trans-  
fer belt as measured in a non-extended press nip.

2. Use as claimed in claim 1, c h a r a c t e r -  
25 i s e d in that the essentially impermeable trans-  
fer belt (16) has an air permeability of less than  
 $6 \text{ m}^3/\text{m}^2/\text{min}$ , measured according to the method stated in  
"Standard Test Method for Air Permeability of Textile  
30 Fabrics, ASTM D 737-75, American Society of Testing and  
Materials".

3. Use as claimed in claim 1 or 2, c h a r a c -  
t e r i s e d in that the polymer layer comprises a  
polymer composition such as acryl polymer resin, poly-  
urethane polymer resin and polyurethane/polycarbonate  
35 polymer resin composition.

4. Use as claimed in any one of claims 1-3,  
c h a r a c t e r i s e d in that the polymer layer com-

prises a particulate filler which has a hardness different from that of the polymer composition, such as kaolin clay, polymer material or metal, preferably stainless steel.

- 5            5. Use as claimed in any one of claims 1-4,  
c h a r a c t e r i s e d    i n    t h a t    t h e    p o l y m e r   l a y e r   c o m -  
p l e t e l y   e n c l o s e s   t h e   c a r r i e r .

6. Use as claimed in any one of claims 1-5,  
characterised in that the carrier is endless.

- 10            7. Use as claimed in any one of claims 1-5,  
c h a r a c t e r i s e d   i n   t h a t   t h e   p o l y m e r   l a y e r   i s  
e m b o s s e d   t o   p r o d u c e   e m b o s s e d   s o f t   t i s s u e .

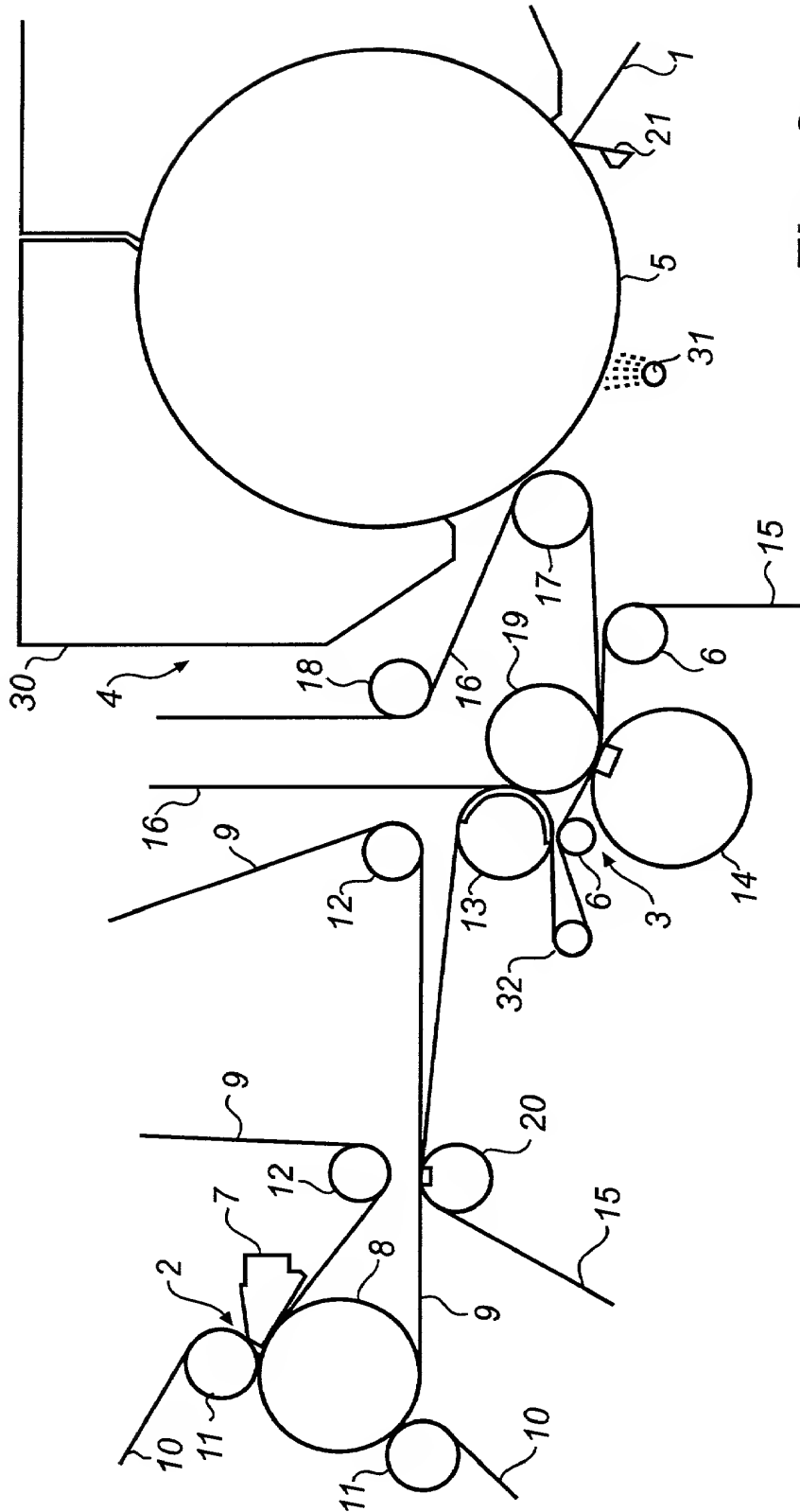
8. Use as claimed in any one of claims 1-7, together with a transfer means which consists of the transfer belt  
15 (16) itself, which runs round a predetermined part of the Yankee cylinder (5) to form an extended transfer nip.

### Abstract of the Disclosure

Use of an essentially impermeable transfer belt (16) for a soft tissue paper machine for conducting a soft tissue web (1) through a shoe press nip in the press section of the paper machine, and from the shoe press nip to a Yankee cylinder (5) in the dryer section of the paper machine in a closed draw. The Yankee cylinder forms, together with a transfer means (17), a transfer nip for transferring the soft tissue web from the transfer belt to the Yankee cylinder. The transfer belt comprises a carrier and an elastically compressible polymer layer on its side facing the web, the polymer layer having a hardness between 50 and 97 Shore A and having a web-contacting surface which has a pressure-sensitive, resettable degree of roughness, the web-contacting surface having a degree of roughness in a non-compressed state of  $R_z = 2\text{-}80\text{ }\mu\text{m}$ , measured according to ISO 4287, Part I, and a lower degree of roughness of  $R_z = 0\text{-}20\text{ }\mu\text{m}$  when the polymer layer is compressed by a linear load of 20-220 kN/m applied to the essentially impermeable transfer belt as measured in a non-extended press nip.

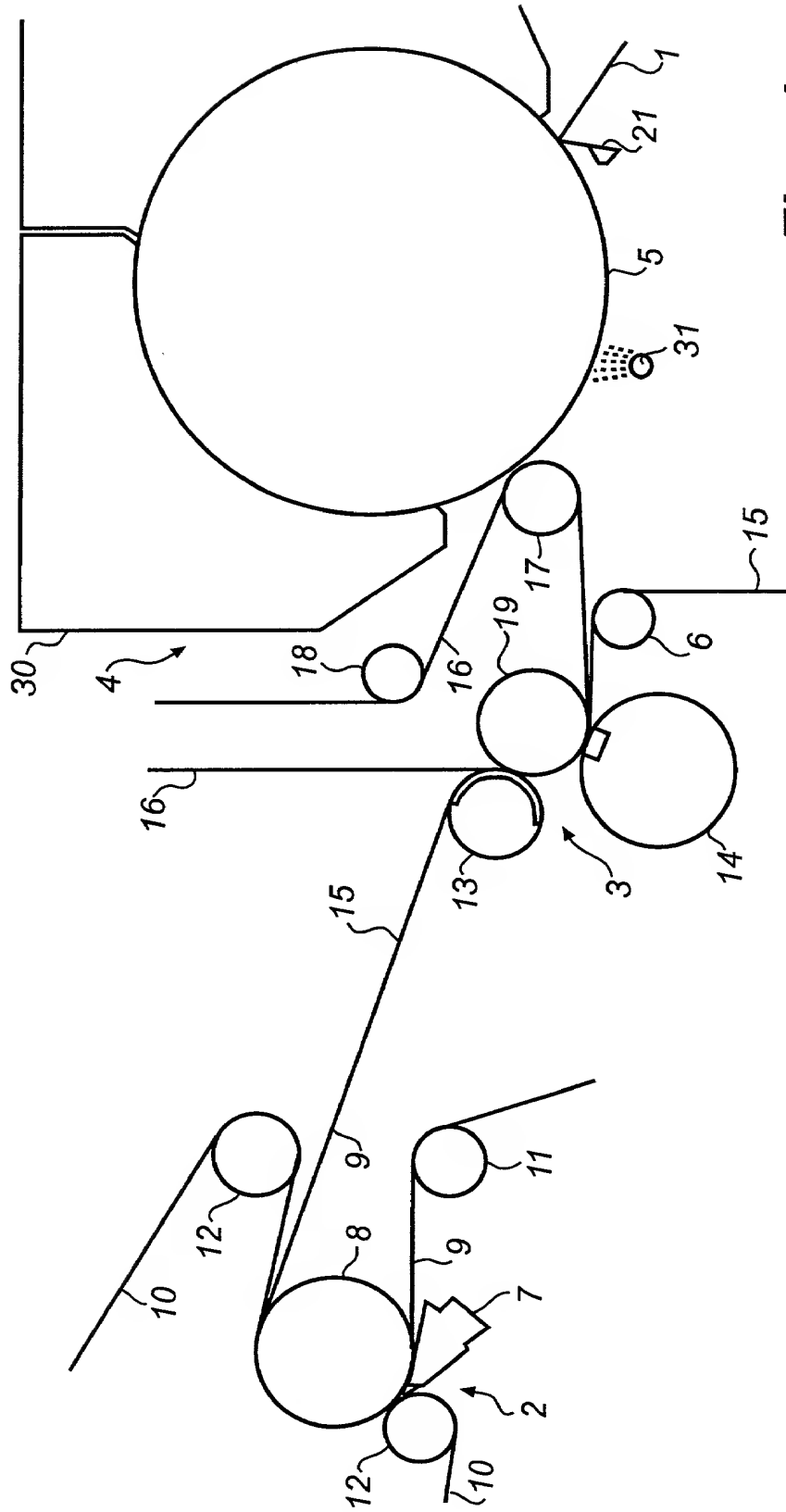






**Fig. 2**





**Fig. 4**